

Date: Thursday, 19/03/2009 11:05:46 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 SADDLE INBOARD, RIGHT SIDE
Job Number : 46581	
Estimate Number : 11014	
P.O. Number :	Part Number : D26682
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D2668 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 37334	Material :
Written By :	Due Date : 05/04/2009 Qty: 8. Um: Each
Checked & Approved By : <u>JUD 09.03.19</u>	
Comment : Est: D 02.03.15 Added DEO 9122 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock: 7075-T7351

Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length

Batch No: B46909 x 7 pcs

B34872 x 1 pcs

J.F. 09/04/09 (8)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on by

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

J.F. / DTP 09/04/11 (8)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. 09/04/14 (8)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / 09/04/11 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:46 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 SADDLE INBOARD, RIGHT SIDE

Job Number: 46581

Part Number: D26682

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MF 09/04/15 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

09-01-15

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110959

START TIME:

4:00

OVEN TEMPERATURE:

320°

FINISH TIME:

11:30

09-04-15

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09/04/15 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

427

9/4/15

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



MF 09-04-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>L4058</u>	
Description: 206 Saddle, Inboard, Right side		Part Number: D2668-2	
Inspection Dwg: D2668 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.109	0.109	0.109	0.109		
B	0.100	0.140		.125	0.123	0.119	0.122		
C	1.125	1.145		1.132	1.1265	1.1325	1.1315		
D	0.615	0.685		.655	0.655	0.655	0.655		
E	0.240	0.260		.252	0.253	0.247	0.255		
F	1.313	1.343		1.320	1.3155	1.316	1.322		
G	0.210	0.220		.215	0.212	0.212	0.217		
H	0.100	0.180		.134	0.125	0.127	0.132		
I	2.470	2.510		2.492	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.566	1.571	1.566		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.115	.115	.115	.118		
M	0.990	1.010		1.002	1.000	1.000	1.001		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.001	6.001	6.001		
P	1.245	1.255		1.249	1.248	1.249	1.249		
Q	2.495	2.505		2.502	2.499	2.499	2.499		
R	0.313	0.318		.313	0.314	0.314	0.314		
S	0.315	0.322		.320	0.320	0.320	0.320		
T	1.995	2.005		1.999	2.000	2.000	2.000		
U	1.357	1.367		1.363	1.362	1.362	1.362		
V	0.787	0.807		.801	0.797	0.796	0.796		
W	1.040	1.060		1.049	1.049	1.048	1.050		
X	1.674	1.684		1.680	1.679	1.679	1.679		
Y	0.257	0.262		.259	0.258	0.258	0.258		
Z	0.912	0.932		.922	0.919	0.917	0.919		
AA	0.490	0.510		.500	0.499	0.499	0.499		
AB	0.178	0.198		.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>J.F.</u>	Audited by: <u>[Signature]</u>
Date: <u>09/24/09</u>	Date: <u>09/24/15</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 46581
Description: 206 Saddle, Inboard, Right side	Part Number: D2668-2
Inspection Dwg: D2668 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.109	0.109	0.112	0.112		
B	0.100	0.140		0.1135	0.1215	0.118	0.118		
C	1.125	1.145		1.1345	1.131	1.138	1.138		
D	0.615	0.685		0.645	0.650	0.660	0.650		
E	0.240	0.260		0.256	0.255	0.250	0.249		
F	1.313	1.343		1.321	1.322	1.325	1.324		
G	0.210	0.220		0.216	0.217	0.220	0.220		
H	0.100	0.180		0.136	0.125	0.125	0.125		
I	2.470	2.510		2.490	2.490	2.493	2.491		
J	1.565	1.585		1.5650	1.5655	1.573	1.572		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.115	.115	.115	.115		
M	0.990	1.010		1.000	1.000	1.001	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.001	6.000		
P	1.245	1.255		1.250	1.249	1.249	1.250		
Q	2.495	2.505		2.499	2.499	2.499	2.499		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.320	0.320	0.320	0.320		
T	1.995	2.005		2.000	2.000	2.000	2.000		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.798	0.795	0.7965	0.795		
W	1.040	1.060		1.047	1.047	1.048	1.047		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.919	0.919	0.919	0.920		
AA	0.490	0.510		0.500	0.500	0.498	0.499		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJT	88
Date: 09/04/11	09/04/14

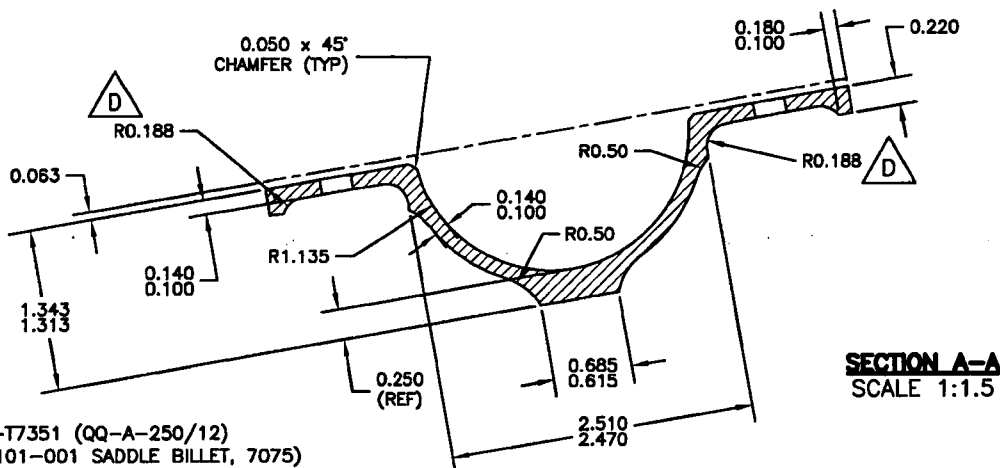
Audited by: [Signature]
Date: 09/04/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8685A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

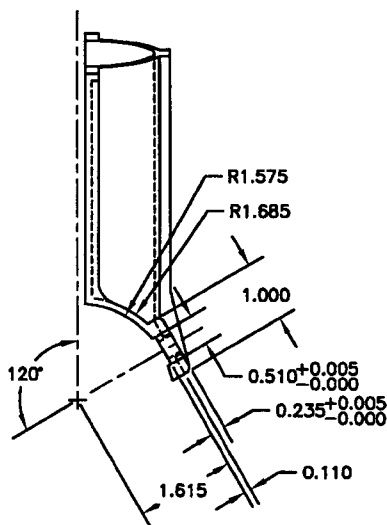
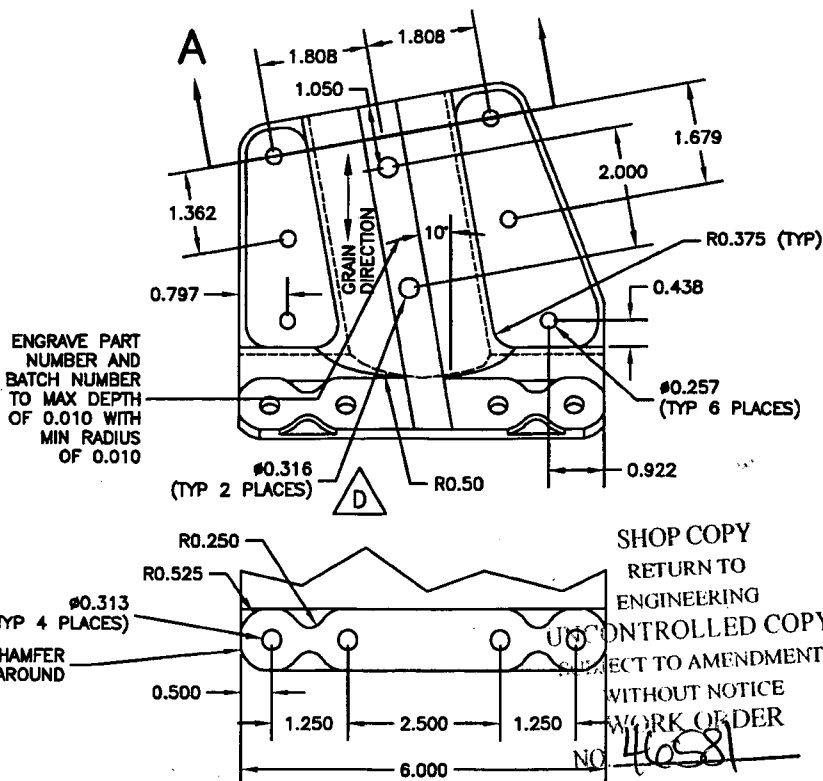
DART

DESIGN A	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED A	DRAWING NO. D2668	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE AFT INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED
07.02.12 **A**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2668-1 SHOWN (D2668-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2668-1 SADDLE AFT INSIDE HIGH**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 46581

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